

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025476**Date Inspected:** 11-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG TA YARD, SEGMENT 14W

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SA3448-001-010, 015, 019

SA3450-001-010, 015, 019

This QA Inspector observed the following work in progress:

OBG Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 048659 perform welding by Shielded Metal Arc Welding (SMAW), on CJP weld joint of Floor Beam (FB) to Deck Plate (DP) of OBG Segment 13AW at PP 119+1500. Weld joint is identified as SEG3013G-107. ZPMC Quality Control (QC) Inspector identified as

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Mr. Wang Xiang Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 049769 perform welding by Shielded Metal Arc Welding (SMAW), on CJP weld joint of I-rib on Floor Beam (FB) to Edge Plate (EP) of OBG Segment 13AW at PP 118. Weld joint is identified as SEG3013G-107. ZPMC Quality Control (QC) Inspector identified as Mr. Wang Xiang Ping was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-Tc-U4b-FCM-1.

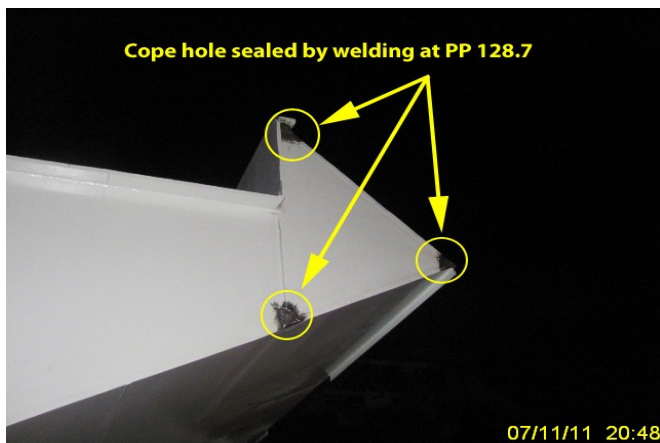
OBG Segment 14E

During random in process inspection this QA Inspector observed that ZPMC personnel were removing the temporary attachments from bottom plate of segment 14E at FL3 area. Please see attached photograph for more details.

OBG Segment 14W

During random in process inspection this QA Inspector observed that ZPMC personnel were performing seal welding to seal the cope holes at PP 128.7. The welder is identified as 200569 perform welding by Shielded Metal Arc Welding (SMAW) process. ZPMC Quality Control (QC) Inspector identified as Mr. Zhu Lin was present to monitor the welding process. See attached photograph for more details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
